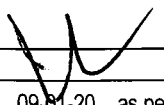


Date: Tuesday, 20/01/2009 2:32:03 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIB
 Job Number : 44959
 Estimate Number : 13746
 P.O. Number :
 This Issue : 20/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38703
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3870 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 27/01/2009 Qty: 8 Um: Each
 Written By : 
 Checked & Approved By :
 Comment : Est Rev:A 09-01-20 as per prelim issue DD verified by:ec

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .250 x 6.00



Comment: Qty.: 0.1750 f(s)/Unit Total: 1.4003 f(s)

6061-T6 Bar .250 x 6.00

batch: 109025 HB 9-1-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3870

Dwg Rev: PRE HB 9-1-21

Prog Rev: Lim



2-Deburr edges and holes if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-1-21

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

10/01/21 (10)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location: WHA

HB 01-01-27

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:32:03 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB

Job Number: 44959

Part Number: D38703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-27

POSITIVE RECALL

RECEIVED 09-01-21 AUTH *[Signature]*

DATE 09.02.17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

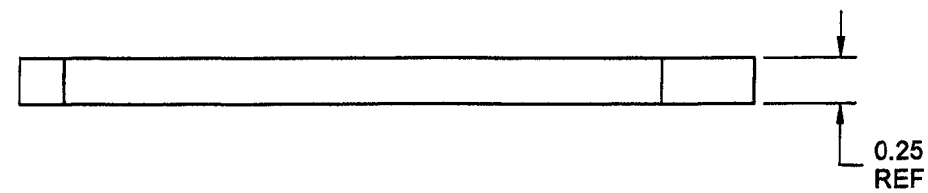
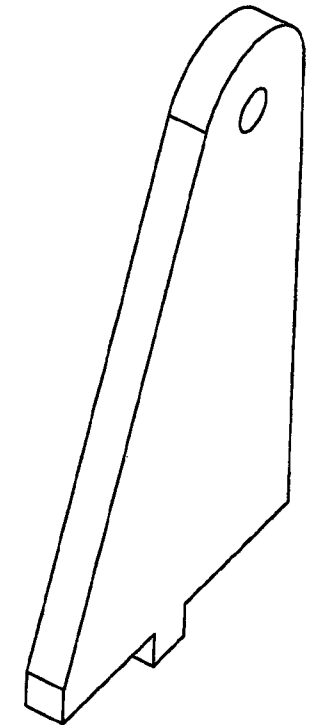
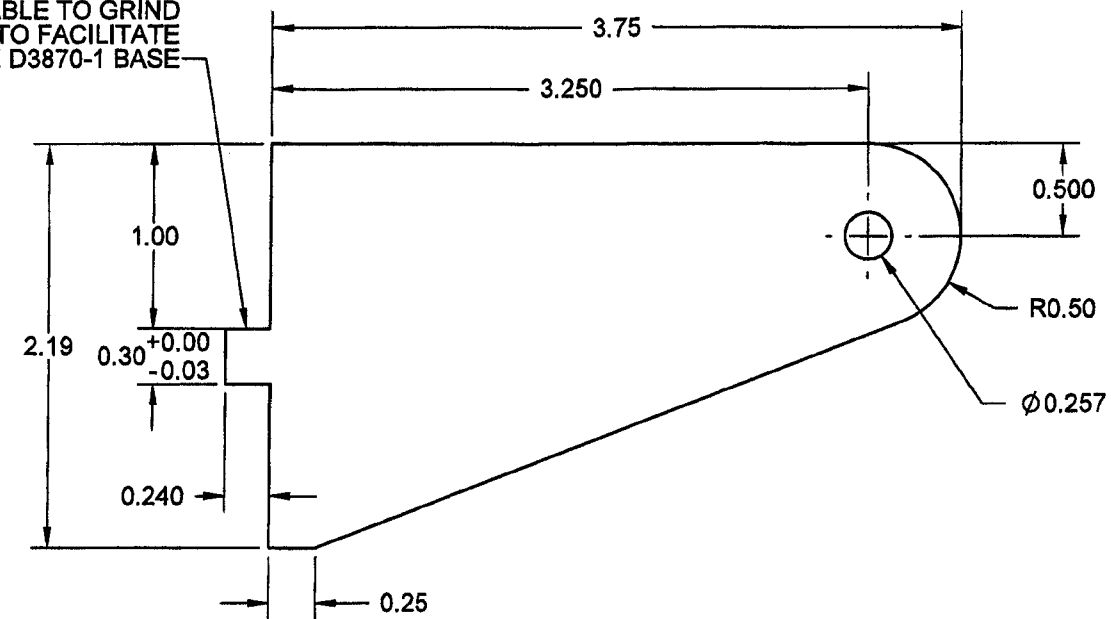
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

IT IS ACCEPTABLE TO GRIND
CORNERS TO FACILITATE
FITTING TO THE D3870-1 BASE



D3870-3 RIB

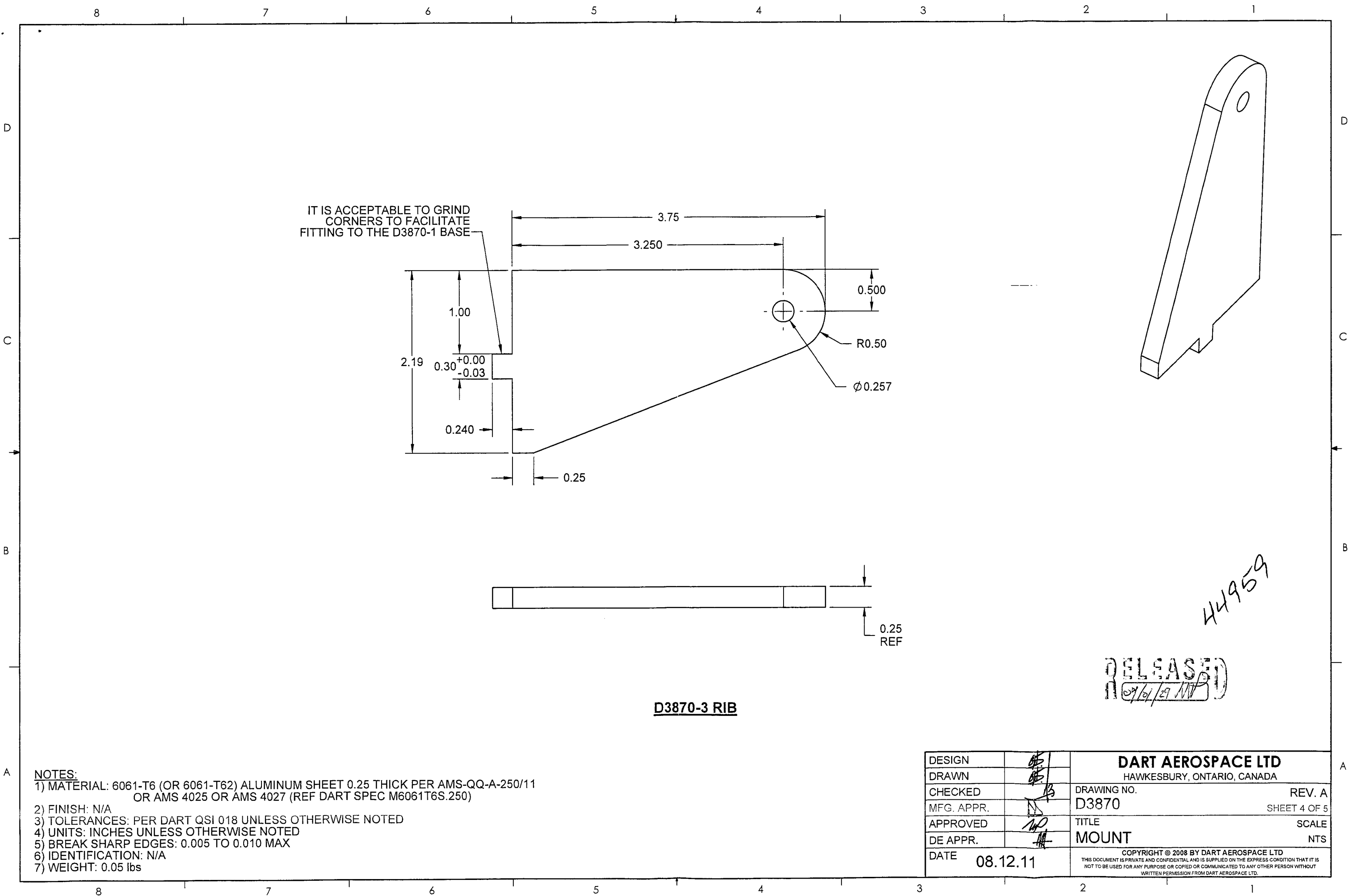
PRELIMINARY ISSUE
09/01/15
44959

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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8 7 6 5 4 3 2 1



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